

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010004**Date Inspected:** 24-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 14-

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG segment 9DE Deck panel I rib to horizontal stiffener splice welds, SEG056E-151 and 160. ZPMC welder was identified as 215553. ZPMC QC is identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4213-TC-U4b-2.

This QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG segment 10AE Side Plate to FL3 Floor beam welds, SEG060A-023 and 024. ZPMC welders were identified as 067764 and 067656. ZPMC QC is identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2214-TC-U4b-FCM-1.

North of Bay 14-

This QA Inspector performed Magnetic Particle Testing (MT) verification of welds previously tested and accepted by ZPMC for OBG Segment 6AW deck panel diaphragm welds, DP138-001-017, 018, 019, 020, 022, 023, 030, 031, 035, 036, 038, 039, 043, 044, 046, 047 051, 053, 054 and 055. Caltrans QA observed two longitudinal linear indications approximately 15 mm in length on welds DP138-001-019 and 020. A incident report was generated this date for the above mentioned MT indications. See attached photos below for additional information.

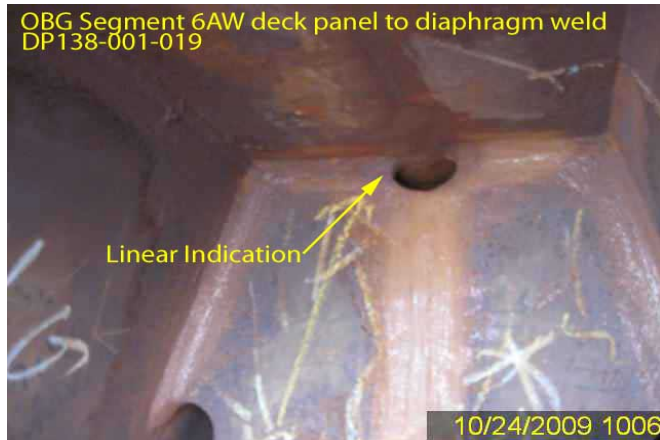
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## WELDING INSPECTION REPORT

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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